

**WHAT IS CLAIMED IS:**

1. A multiple layer interlayer useful for blocking the transmission of  
5 infra red (IR) light, comprising: (1) at least two thermoplastic polymer  
sheets; and (2) a film, positioned between the thermoplastic polymer  
sheets such that the film is in direct contact on each of its surfaces with  
the sheets, wherein the film can either reflect or absorb IR light, and  
wherein the thermoplastic polymer sheets are unplasticized.  
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2. A multiple layer interlayer useful for blocking the transmission of  
infra red (IR) light, comprising: (1) at least two thermoplastic polymer  
sheets; and (2) a film, positioned between the thermoplastic polymer  
sheets such that the film is in direct contact on each of its surfaces with  
15 the sheets, wherein the film can either reflect or absorb IR light, and  
wherein the thermoplastic polymer sheets comprise unplasticized  
ethylene/unsaturated acid copolymer ionomer.
3. A glass laminate useful for blocking the transmission of IR light,  
20 comprising a multiple layer interlayer comprising: (1) at least two  
thermoplastic polymer sheets; and (2) a film, positioned between the  
thermoplastic polymer sheets such that the film is in direct contact on  
each of its surfaces with the sheets, wherein the film can either reflect or  
absorb IR light, and wherein the thermoplastic polymer sheets do not  
25 include plasticizer.
4. A glass laminate useful for blocking the transmission of IR light,  
comprising a multiple layer interlayer comprising: (1) at least two  
thermoplastic polymer sheets; and (2) a film, positioned between the  
30 thermoplastic polymer sheets such that the film is in direct contact on  
each of its surfaces with the sheets, wherein the film can either reflect or  
absorb IR light, and wherein the thermoplastic polymer sheets comprise  
an unplasticized copolymer of ethylene and an unsaturated acid wherein  
the acid groups of the copolymer have been at least partially neutralized  
35 to yield an ethylene/unsaturated copolymer ionomer.

5. A process for manufacturing a multiple layer laminate article of the present invention comprising the steps: (1) priming at least one of the multiple layers of the laminate by application of a primer solution before assembling the layers; (2) assembling at least three layers to be used as component layers for the laminate article, wherein at least one layer is an IR-blocking film, and wherein at least two of the layers are unplasticized thermoplastic polymer sheets; (3) positioning the IR-blocking film such that it is contacted on its major surfaces by the unplasticized polymer sheets; and, (4) laminating the at least three layers by heating the assembled layers at a temperature of at least 120°C and at a pressure greater than atmospheric pressure.
6. The process of Claim 5 wherein the priming solution comprises a silane compound.
7. The process of Claim 6 wherein the silane compound is an aminosilane such as gamma-aminopropyltriethoxysilane or N-(2-aminoethyl)-3-aminopropyltrimethoxysilane or similar hydrolyzable amino silanes.